

Work Order ID 60670

Monday, July 19, 2010 8:50:10 AM

Page 1

Item ID: D3826-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib / Gusset Assembly

Start Date: 7/19/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 7/23/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: H Date: 10-7-19 Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3826

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- use DT9434 to assemble D2325 support gusset together □ 2- locate D2325 on
rib and weld as per dwg D3826 □ A/R ER316 S.S. RodBatch: 102
M109213Cpl 10.07.23

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

⑥ PD 10.07.26

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

S 10/6/126⑫

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
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Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: WA

0.00

SAD



Packaging

Memo

0.00

10-07-26

(6)

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/26 JF

R10-7-26
(4)

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Monday, July 19, 2010 8:50:13 AM

Parent Item: D3826-041

Parent Item Name: Rib / Gusset Assembly




Start Date: 7/19/2010

Required Date: 7/23/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2235-1  Basket Rib		Manufactured	No				Each	14.0000	1	6		<i>Cpl 10.07.22</i>	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA			14						
					59925		4						
					60274		10						
D3929-041  Gusset Assembly		Manufactured	No				Each	11.0000	1	6		<i>Cpl 10.07.22</i>	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA			11						
					59927		5						
					60327		6						
D3929-042  Gusset Assembly		Manufactured	No				Each	6.0000	1	6		<i>Cpl 10.07.22</i>	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA			6						
					59979		6						

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

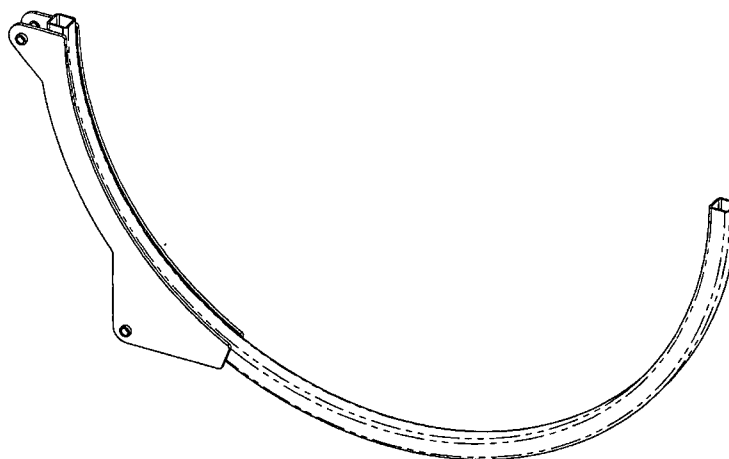
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY



D3826-041 RIB/GUSSET ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60670
2810-719

RELEASED
8/10/12 MB

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 3.32 lbs

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.	MB	09.04.16
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>MB</u>		
DRAWN	<u>MB</u>		
CHECKED	<u>MB</u>		
MFG. APPR.	<u>MB</u>		
APPROVED	<u>MB</u>		
DE APPR.	<u>MB</u>		
DATE	09.04.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3826** REV. B
TITLE **RIB/GUSSET ASSY** SCALE
NTS

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B D3929-042
GUSSET ASSEMBLY

B D3929-041
GUSSET ASSEMBLY

TYP

0.250

D2235-1
RIB

D3826-041 RIB/GUSSET ASSY

w/o 60670

RELEASED
9/10/12

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3826	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		RIB/GUSSET ASSY	NTS
DATE	09.04.16	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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